

Taps Xtap

Incool

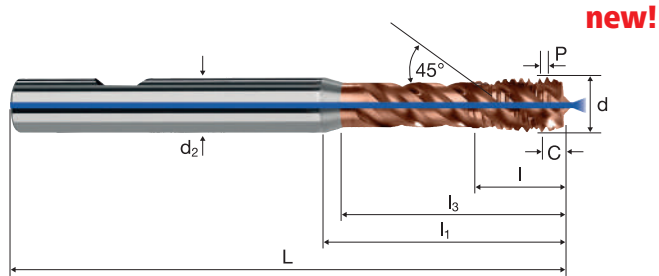


M ISO 2
(6H)

HSS
PM/F

DIN
1835B
ISO
3338

X-P
Form C

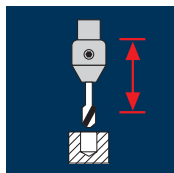


Rm < 850 HRC < 24 Rm 850-1100 HRC 24-34 **Inox** Stainless

M
MF
G
UN
EG

Example: Order-N°.		Article-N°.		α-Code						AlCrTiN	
		EC10580		058						EC10580	
Ø Code	d	P	L	I	I ₁	I ₃	d ₂	3	3.30		
058	M 4	0.70	66	7.00	21.0	19.0	6.0	3	3.30		●
084	M 5	0.80	70	8.00	25.0	23.0	6.0	3	4.20		●
088	M 6	1.00	80	10.00	30.0	28.0	6.0	3	5.00		●
160	M 8	1.25	90	13.00	35.0	33.0	8.0	3	6.80		●
174	M 10	1.50	100	15.00	39.0	37.0	10.0	4	8.50		●
240	M 12	1.75	110	18.00	45.0	43.0	12.0	4	10.20		●
244	M 14	2.00	110	20.00	46.0	44.0	16.0	4	12.00		●
246	M 16	2.00	110	20.00	50.0	48.0	16.0	4	14.00		●
312	M 18	2.50	125	25.00	60.0	58.0	16.0	4	15.50		●
314	M 20	2.50	140	25.00	64.0	62.0	16.0	4	17.50		●
316	M 22	2.50	140	25.00	64.0	62.0	20.0	5	19.50		●
320	M 24	3.00	160	30.00	74.0	72.0	20.0	5	21.00		●
											●
											●
											●
											●
											●
											●
											●
											●
											●
											●

Application



Material

Steel
500 - 850 N/mm²



Steel
500 - 850 N/mm²



Steel
850 - 1100 N/mm²



Steel
850 - 1100 N/mm²



Stainless steel
ferritic/martensitic



Stainless steel
ferritic/martensitic



Stainless steel
[Cr-Ni/1.4301]



Stainless steel
[Cr-Ni/1.4301]



M	d [mm]	P [mm]	v_c 1.0 x d	n [min ⁻¹]	v_c 1.5 x d	n [min ⁻¹]	v_c 2.0 x d	n [min ⁻¹]
M4	4.000	0.70	28	2230	24	1910	18	1430
M5	5.000	0.80	28	1785	24	1530	18	1145
M6	6.000	1.00	28	1485	24	1275	18	955
M8	8.000	1.25	28	1115	24	955	18	715
M10	10.000	1.50	28	890	24	765	18	575
M12	12.000	1.75	28	745	24	635	18	475
M14	14.000	2.00	28	635	24	545	18	410
M16	16.000	2.00	28	555	24	475	18	360
M18	18.000	2.50	28	495	24	425	18	320
M20	20.000	2.50	28	445	24	380	18	285
M22	22.000	2.50	28	405	24	345	18	260
M24	24.000	3.00	28	370	24	320	18	240
M4	4.000	0.70	22	1750	18	1430	12	955
M5	5.000	0.80	22	1400	18	1145	12	765
M6	6.000	1.00	22	1165	18	955	12	635
M8	8.000	1.25	22	875	18	715	12	475
M10	10.000	1.50	22	700	18	575	12	380
M12	12.000	1.75	22	585	18	475	12	320
M14	14.000	2.00	22	500	18	410	12	275
M16	16.000	2.00	22	440	18	360	12	240
M18	18.000	2.50	22	390	18	320	12	210
M20	20.000	2.50	22	350	18	285	12	190
M22	22.000	2.50	22	320	18	260	12	175
M24	24.000	3.00	22	290	18	240	12	160
M4	4.000	0.70	12	955	10	795	8	635
M5	5.000	0.80	12	765	10	635	8	510
M6	6.000	1.00	12	635	10	530	8	425
M8	8.000	1.25	12	475	10	400	8	320
M10	10.000	1.50	12	380	10	320	8	255
M12	12.000	1.75	12	320	10	265	8	210
M14	14.000	2.00	12	275	10	225	8	180
M16	16.000	2.00	12	240	10	200	8	160
M18	18.000	2.50	12	210	10	175	8	140
M20	20.000	2.50	12	190	10	160	8	125
M22	22.000	2.50	12	175	10	145	8	115
M24	24.000	3.00	12	160	10	135	8	105
M4	4.000	0.70	7	555	5	400	4	320
M5	5.000	0.80	7	445	5	320	4	255
M6	6.000	1.00	7	370	5	265	4	210
M8	8.000	1.25	7	280	5	200	4	160
M10	10.000	1.50	7	225	5	160	4	125
M12	12.000	1.75	7	185	5	135	4	105
M14	14.000	2.00	7	160	5	115	4	90
M16	16.000	2.00	7	140	5	100	4	80
M18	18.000	2.50	7	125	5	90	4	70
M20	20.000	2.50	7	110	5	80	4	65
M22	22.000	2.50	7	100	5	70	4	60
M24	24.000	3.00	7	95	5	65	4	55